

Work Order ID 79105

Friday, January 20, 2012 8:26:57 AM

79105

Page 1

Item ID: D4410-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Face Plate

Stop

NS2

Start Date: 1/20/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/20/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: CNFDate: 12-01-20

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4410

A

100

0.00

100

Waterjet

0.00

FLOW CNC Waterjet

6561-040

Memo

CUT AS PER DWG

DWG REV: APROG REV: P

DEBURR

B 12-1-20

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

B 12-1-20

Work Order ID 79105***79105***

Page 2

Friday, January 20, 2012 8:26:57 AM

Item ID: D4410-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Face Plate

Start Date: 1/20/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/20/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		5.1260170		(x5)			
170 *170* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O: Black Anodize as per Dwg D4410	0.00 0.00							
180 *180* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	130	- Stan took 1 piece for HAI show. - remaining 3 will be analysed <i>Strapped</i>					
			<i>updated to new Rev</i>	<i>mtf 12-07-09</i>			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79105***79105***

Page 3

Item ID: D4410-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Face Plate

Stop ***NS2***

Start Date: 1/20/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/20/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

220

Identify as per dwg & Stock Location: _____

0.00

220

Packaging

0.00

Packaging

Memo

Packaging

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.00

Quality Control

03700

ME 12-07-09

Picklist Print

Friday, January 20, 2012 8:26:57 AM

Page 1

Work Order ID: 79105

Parent Item: D4410-3

Parent Item Name: Face Plate

Start Date: 1/20/2012

Required Date: 1/20/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-11-02 JLM VERIFIED:BY:DD

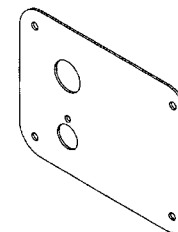
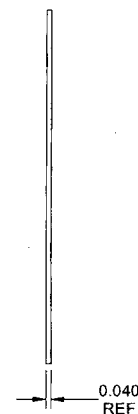
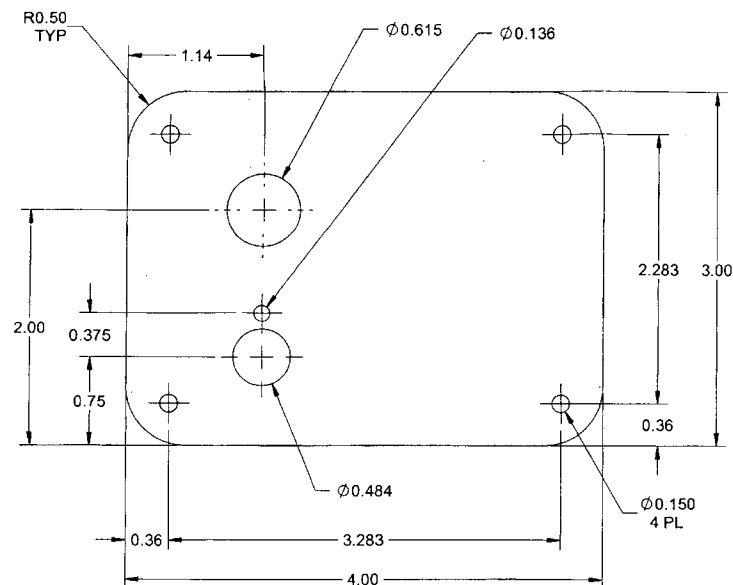
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No				sf	331.9100		0.0947368			

12-1-20

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	331.91	
113004	3.5	
117653	40.91	
120154	95.5	
120218	192	

113004

4



D4410-3 FACE PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

#79105

RELEASED
2011-10-3
UNP

DESIGN	BC	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	BC		
CHECKED	BC	DRAWING NO. D4410	REV. A
MFG. APPR.	BC	SHEET 4 OF 7	
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CO-PILOT COLLECTIVE HEAD	NTS
DATE	11.06.06	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Work Order: 79105

Part Number: D 4410-3

Page 1 of 1

X	First Article	X	Prototype
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Measured by: B	Audited by: 8	Prototype Approval:
Date: 12-1-20	Date: 12/1/20	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	